

Date: Thursday, 11/06/2009 1:59:26 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 SADDLE, INBOARD, LEFT SIDE
Job Number : 48516
Estimate Number : 11771
P.O. Number :
This Issue : 11/06/2009 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : MACHINED PARTS
Previous Run :
Written By : *[Signature]*
Checked & Approved By :
Comment : Est: C 00.06.22 Removed P/O for powder coat EC
Est Rev:D As per Rev D 07-03-19 JLM

Part Number : D26621
Drawing Number : D2662 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 18/06/2009 Qty: 6 Um: Each

TYPE
SALLISU

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

1.0 D6101001

Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock: 7075-T7351.1

Cut Size 2.0 x 6.25 X 6.0 Grain Along

Long 6.0 Length

Batch No: _____

09/06/14

2.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

Inspect part number and batch number are programmed correctly.

Fixturing Inspection last completed _____ by _____

Machine Step No 1 of Folio and inspect per attached Dimension Sheet

Machine Step No 2 of Folio and inspect per attached Dimension Sheet

Machine Step No 3 of Folio and inspect per attached Dimension Sheet

Machine Step No 4 of Folio and inspect per attached Dimension Sheet

Deburr

09/06/14

3.0 MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 SADDLE, INBOARD, LEFT SIDE

Job Number: 48516

Part Number: D26621

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

7.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT

9.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

10.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECT

ELEA

Handwritten signature
DATE: _____
DA: _____

DART AEROSPACE LTD	Work Order: 48516
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140							
B	0.100	0.140							
C	1.125	1.145							
D	0.615	0.685							
E	0.240	0.260							
F	1.313	1.343							
G	0.210	0.230							
H	0.100	0.180							
I	2.470	2.510							
J	1.565	1.585							
K	0.235	0.240							
L	0.100	0.120							
M	0.990	1.010							
N	0.510	0.515							
O	5.990	6.010							
P	1.245	1.255							
Q	2.495	2.505							
R	0.313	0.318							
S	0.315	0.322							
T	2.495	2.505							
U	1.357	1.367							
V	0.787	0.807							
W	0.540	0.560							
X	1.674	1.684							
Y	0.257	0.262							
Z	0.912	0.932							
AA	0.490	0.510							
AB	0.178	0.198							
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	
Date:	

Audited by	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 48516
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140							
B	0.100	0.140							
C	1.125	1.145							
D	0.615	0.685							
E	0.240	0.260							
F	1.313	1.343							
G	0.210	0.230							
H	0.100	0.180							
I	2.470	2.510							
J	1.565	1.585							
K	0.235	0.240							
L	0.100	0.120							
M	0.990	1.010							
N	0.510	0.515							
O	5.990	6.010							
P	1.245	1.255							
Q	2.495	2.505							
R	0.313	0.318							
S	0.315	0.322							
T	2.495	2.505							
U	1.357	1.367							
V	0.787	0.807							
W	0.540	0.560							
X	1.674	1.684							
Y	0.257	0.262							
Z	0.912	0.932							
AA	0.490	0.510							
AB	0.178	0.198							
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	
Date:	

Audited by	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

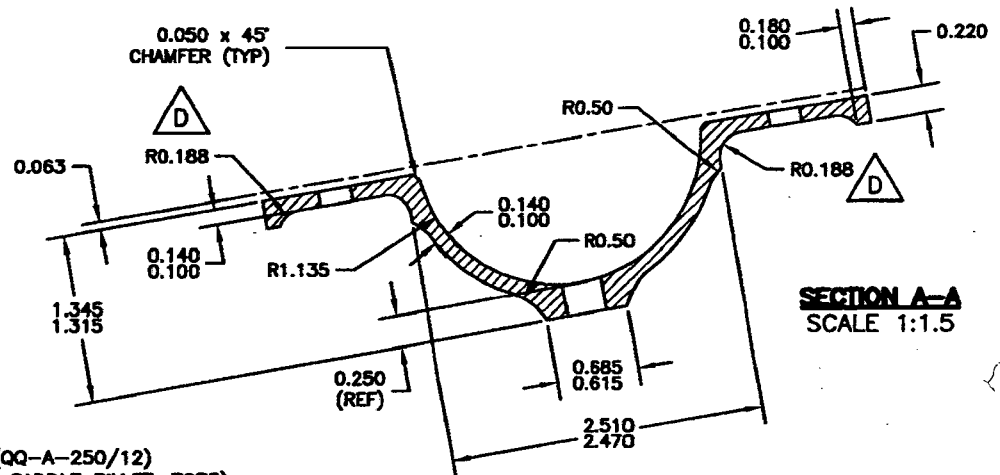
DART

DESIGN A	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED A	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

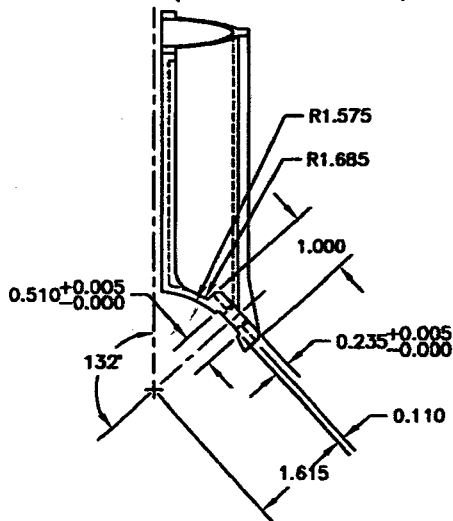
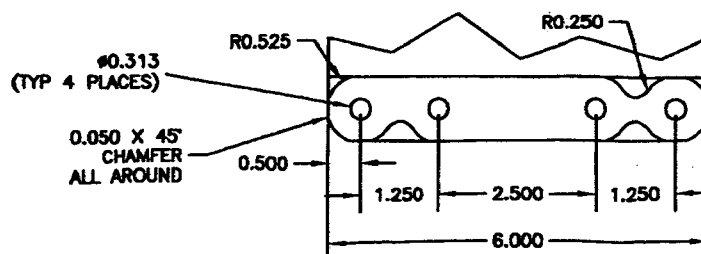
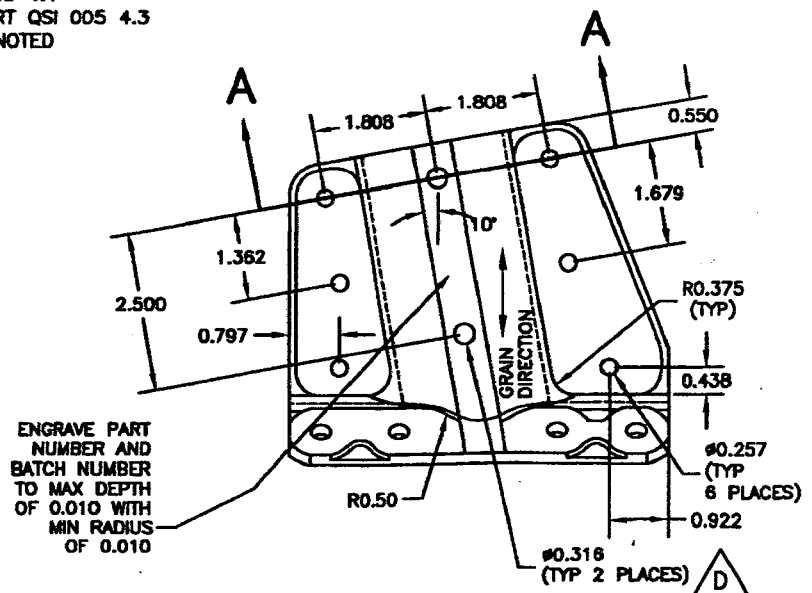
RELEASED

07.02.02

w/04/8516

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

**D2662-1 SADDLE INSIDE**

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Work Order Summary

December 2, 2009 1:12:40 PM

Criteria : Work Order ID: 48516 Item ID: D2662-1RevD Product Family MACHINING
Work Order Start Dates 7/15/09 to 7/15/09 11:59:59 PM Work Order Required Dates 8/03/09 to 8/03/09
11:59:59 PM
All References
Work Order Status Released

Page 1 of 2

Work Order ID 48516
Item ID D2662-1RevD
Item Name Saddle, LH In 206
Current Acct Value \$78.670
Start Date 7/15/09
Standard
Required Date 8/03/09
Sales Order ID
Completed Date
Required Qty 6.0000
Accepted Qty 0.0000
Status Code Released
Scrap Qty 0.0000

Direct Costs	** Actual **		** Acct. Value **		** Variance **		** Variance % **	
	Total	Each	Total	Each	Total	Each	Total	Each
Material	\$0.000	\$0.000	\$45.100	\$45.100	\$45.100	\$45.100	100.00%	100.00%
Labor	\$182.224	\$0.000	\$10.310	\$10.310	\$10.310	\$10.310	0.00%	0.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	\$0.000	\$0.000	0.00%	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	\$0.000	\$0.000	0.00%	0.00%
Fixed Burden	\$416.708	\$0.000	\$23.260	\$23.260	\$23.260	\$23.260	100.00%	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	\$0.000	\$0.000	0.00%	0.00%
** Total **	\$598.932	\$0.000	\$78.670	\$78.670	\$78.670	\$78.670	0.00%	0.00%

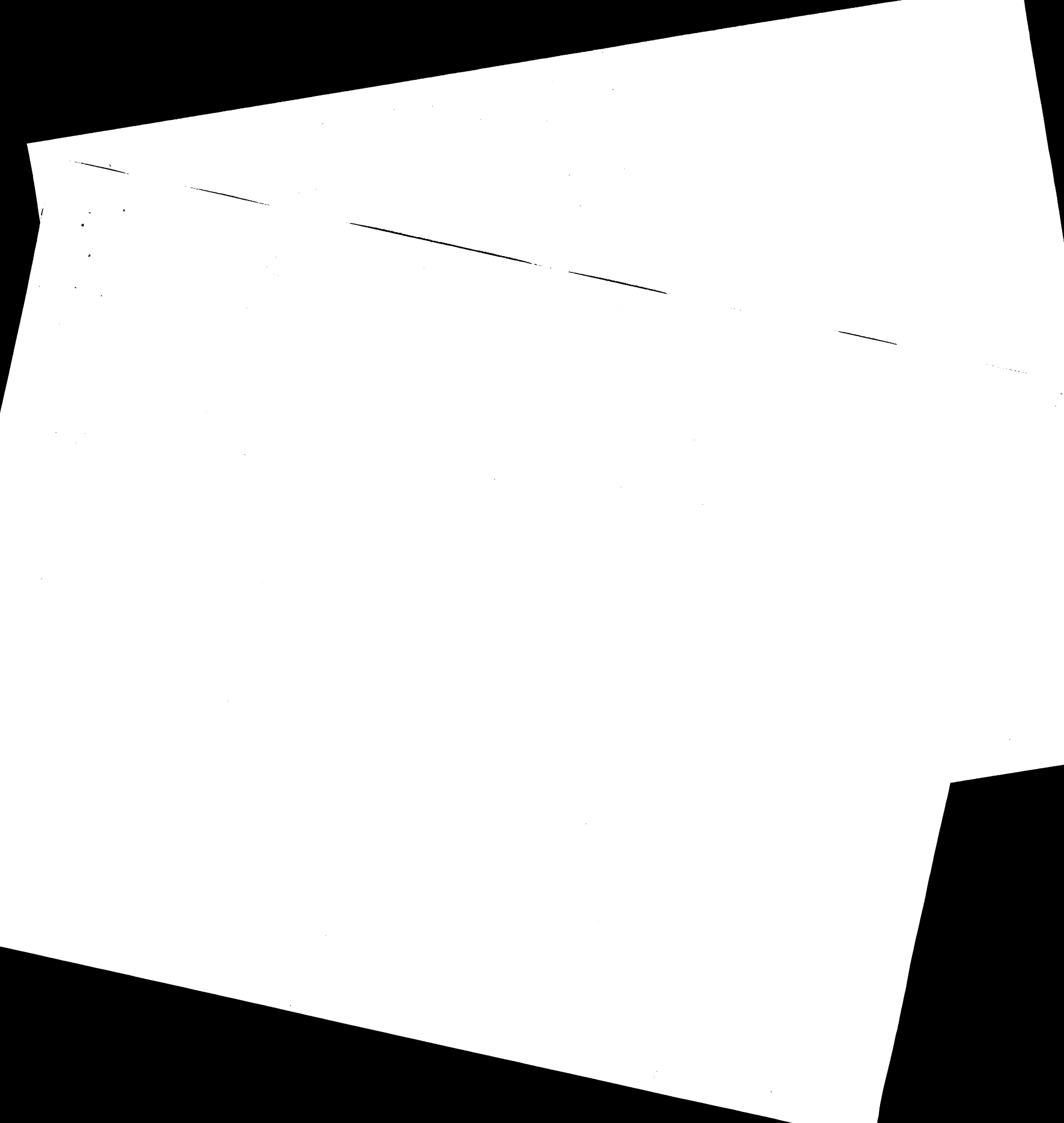
Work Center												Total Amounts
Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	
ZWIP		6/26/09										
N/A												
N/A												
Total:			0.00	0.00	51.71	51.71	1.00	\$0.000	\$51.710	\$129.275	\$0.000	\$180.98
			0.00	0.00	1.79	1.79	1.00	\$0.000	\$1.785	\$0.000	\$0.000	\$1.78
			0.00	0.00	53.50	53.50	2.00	\$0.000	\$53.495	\$129.275	\$0.000	\$182.77

Work Center HAAS I

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
AUCL01		9/28/09										
100			0.00	0.00	5.53	5.53	1.00	\$0.000	\$97.629	\$217.993	\$0.000	\$315.62
100		11/17/09	0.00	0.00	0.00	0.00	1.00	\$0.000	\$0.000	\$0.000	\$0.000	\$0.00
100		11/21/09	0.00	0.00	0.02	0.02	1.00	\$0.000	\$0.339	\$0.757	\$0.000	\$1.09
drou01		10/30/09	0.00	0.00	1.72	1.72	1.00	\$0.000	\$30.314	\$67.687	\$0.000	\$98.00

Work Order Summary

December 2, 2009 1:12:40 PM



Date: Wednesday, 12/02/09 1:14:57 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 48516	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 11771	DWG Name	: 206 SADDLE, INBOARD, LEFT SIDE
Purchase Order #	:	Part Number	: D26621
Complete Date	: / / : : AM	DWG Number	: D2662 REV D
Rev.	: D		

DUE DATE	ORDERED	DELIVERED
6/18/09	6	0

2.0 HAAS1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
6/15/09	FOUR01: Fournier, Sebastien	Run	0.000	2.53	\$44.65	2.53	99.57
6/17/09	FORT01: Fortin, Mathieu	Run	0.000	0.40	\$7.06	0.80	31.49

Subtotal: QTD: 0 CTD: 0 2.93 \$182.77

	TIME	COST
Machine Time:	3.33	\$131.06
Labor:	2.93	\$51.71
Sub-contract (external Op.):		\$0.00
INVENTORY ITEM:		\$0.00
SUB-COMPONENT (SUB-JOB):		\$0.00
Total:		\$182.77

COST PER UNIT: \$182.77